Thursday, 12/20/2007 3:20:09 PM Kim Johnston User: **Process Sheet** : CUP : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 36482 : 13106 **Estimate Number** : D30093-Part Number P.O. Number D3009 UNDER REVIEW S.O. No. : **Drawing Number** : 12/20/2007 This Issue : N/A : NC Project Number Prsht Rev. : U/R 3 : SMALL /MED FAB **Drawing Revision** : 11 Type First Issue : 36431 Material Previous Run : 1/10/2008 80 Um: Qty: Each Due Date Written By Checked & Approved By EC new issue Comment **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 1.0 M304R1000 Inventory Comment: Qty.: Total: 4.0236 f(s) 0.0503 f(s)/Unit 1018 7/8 ROUND BAR Material: AISI304/316-65 1.00" Ø Round Bar 151 108-1025 (M304R1000) MINIB-R Batch: <u>M15425</u> HARDINGE CNC LATHE SMALL HARDINGE 2.0 Comment: 1-TURN AS PER FOLIO FA130 & DWG D3009 FOLIO REV:___ DWG REV: 2-DEBURR AS REQUIRED INSPECT PARTS AS THEY 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

−Page

Form: rorocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
68.07.18	5	STOCK AS D3009-1				P		
00.07.70		CP SPEC'D MAT'L FOR -1 IN ERROR				08.07.18 QSI 047		

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	Date:

cation Appro	Annewal Annewal
cation Appro	Eng QC Inspector
	•

NOTE: Date & initial all entries

Date:

Thursday, 12/20/2007 3:20:09 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUP

Job Number: 36482

Part Number: D30093

Job Number:

Seq. #:

Machine Or Operation:

Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/07/18df

Dart Ae	rospace Lt	d							
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date:	,
					QA:	N/C Close	d:	Date:	
NCR:		,	WORK ORDE	R NON-CONFORMAN	NCE (NC	R)			
		Description of NC		Corrective Action Section	. В	Vorifi	cation	Approval	Approval
DATE	STEP	Section A	Initial	Action Description	Sign	& Sect	ion C	Approval Chief Eng	Approval QC Inspector

NCR:		·	WORK ORD	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Annroyal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector

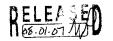
NOTE: Date & initial all entries

R0.062 R0.032 x 45° CHAMFER 0.094 0.063 (REF)

SECTION A-A

Ø 0.266 (DRILL 17/64", REF) THRU Ø0.750 Ø 0.875^{+0.000}_{-0.005} D3009-1 CUP

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 36482



D

С

REDRAW/REFORMAT DWG, D3009-1 MAT'L WAS 1010-1025 NOW 1018-1025 (A8), 0.353 WAS 0.363 (D7), Ø0.266 WAS Ø0.257 (C5), ADD D3009-3 (SHEET 2) 07.12.12 NEW ISSUE RF 01.03.23 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. B D3009 MFG. APPR. SHEET 1 OF 2 TITLE APPROVED SCALE CUP DE APPR. 2:1 DATE 07.12.12

NOTES: 1) MATERIAL:AISI 1018-1025 ROUND BAR (REF DART SPEC M1018-R)

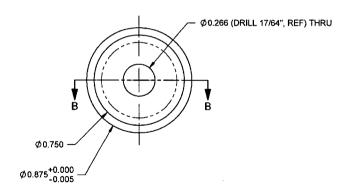
(REF DART SPEC M1018-R)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

8

6

2

R0.062 -R0.032 x 45* CHAMFER 0.094 0.353 0.063 SECTION B-B



D3009-3 CUP

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 36487

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DESIGN	91	DART AERO	OSPACE LTD			
DRAWN	0	HAWKESBURY, ONTARIO, CANADA				
CHECKED	B	DRAWING NO.	REV. B			
MFG. APPR.	17	D3009	SHEET 2 OF 2			
APPROVED	#	TITLE	SCALE			
DE APPR.	-#-	CUP	2:1			
DATE 07.1	2.12	THIS DOCUMENT IS PRIMATE AND CONFIDENTIAL AS NOT TO BE USED FOR ANY PURPOSE OR CORED	LY DART AEROSPACE LTD ND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS OR COMMUNICATED TO ANY CITIER PERSON WITHOUT FROM DART AFROPACE LTD.			

NOTES:
1) MATERIAL:AISI 304/316 STAINLESS STEEL ROUND BAR
(REF DART SPEC M304R)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

8

DART AEROSPACE LTD	Work Order: 36482
Description:	Part Number: \(\sum_30093
Inspection Dwg: Rev: S	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.353	±.010	.352	V			
.094	±.010	092	V			
Ø.750	010° =	,747	V			
Ø.875	+ .000	.874	\checkmark			
8.062	4.010	6000	J			
R032×45°	+.010×±1/2°	244500	\ \			
(RE) 0063	1					
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			-			
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					and the second s	
	AA.J					

Measured by:	Audited by:	Prototype Approval:	\Box
Date: 8 07 15	Date: 08/07/17	Date:	h (k)

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

